

Work Order ID 142026

Tuesday, February 23, 2016 2:25:18 PM

142026

Page 1

Item ID: D350-604-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rear Locker Extender

Start Date: 2/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: ML5 Date: FEB 24 2016

Tooling:

Date:

Run Start

NR1

QC: Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Rev. Nbr

DAS

D2273

10

D350-604-041

C

9-89

Re

AUG 29 2016

DAS
21
9-89

16-08-29

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-604-041
CHG009

110

110

Purchasing

PURCHASING

0.00

Memo

0.00

Purchasing

Issue P/O: 31489
Description: D350-604-041 Rear locker extender.
Manufacture as per dwg D2273
Supplier: FDC Composites Inc.
Certification of Conformity and process sheet required.

1 FEB 25 2016

DAS
13
9-89

***EXTREME CARE MUST BE TAKEN TO PROTECT THE SURFACES OF
THE REAR LOCKER. THE SURFACES MUST BE SMOOTH AND FREE
FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR
DENTS.***

MUST BE WELL PACKAGE, IF NOT IT WILL BE REFUSE

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY					
☐ Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence			
☐ OTHER : _____								

Work Order ID 142026***142026***

Page 2

Tuesday, February 23, 2016 2:25:18 PM

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Rear Locker Extender

Stop ***NS2***

Start Date: 2/23/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure a copy of Certification of Conformity and process sheet from Carbon-by-Design is attached.								
	DO NOT STACK REAR LOCKERS OR ANYTHING ON THEM								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Check hole locations to template. DT 8824 Check process sheet and audit.								
140		0.00							
140									
Small Fab	Memo	0.00							
Small Fab	1- INSTALL DECALS AS PER DWG								

P.T.O.

SEP 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								



Supplier Non-Conformance Report

Reviewed		SEP 14 2016	Printed on:	Friday, August 26, 2016
DQA:				
Date:				

Details

Raised Date 5/27/2016	Status Open	Owner Downing, Eric M	Number NCR16-5805
Target Date 9/30/2016	Standard		Severity
Process Inspection		Audit	
Raised By Person Duval, Patrick	Raised Against (Department or Supplier) FDC Composites Inc.		Fault Category General\Cracked
Details crack found in gel coat of D350-604-041 on PO31489 B142029, B142021, B142026, B142019 and B141779			
Keywords D350-604-041		Product D350-604\D350-604-041	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action

Target Date 9/28/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details			
Response			
1	Downing, Eric M	9/28/2016	
Contact Supplier and obtain corrective action			
2	Duval, Patrick	8/26/2016	8/26/2016
acceptable as is. No structural affect		stock	

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
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Description Work Order Deviation		Disposition			Completed By	
					Lead hand / Supervisor Approval Verification	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐						

Work Order ID 142026***142026***

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Tuesday, February 23, 2016 2:25:19 PM

Item ID: D350-604-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rear Locker Extender

Start Date: 2/23/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/10/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Packaging	0.00							
160									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-604-041								
	Location: _____								
	PPP Rev: _____								
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

SEP 06 2016

DAS
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SEP 06 2016

dem 16/09/06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
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Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Page 1

Work Order ID: 142026

142026

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 2/23/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:Q03.12.01ReformatKJ/RF IPP REV:R
 12.02.07 AS PER ECN12-521 DD verf:JLM IPP REV:S 12.04.04
 AS PER DWG REV.B DD VERF:EC IPP REV:T 13.09.12 as per
 CHG006/ECN13-616 DDVERF:JLM IPP REV:U 14.05.28 as per
 chg008/ecn14-563 DD verf:JLM IPP REV:V 15.03.13 remove cam lock and
 washerDD verf:JLM IPP REV:W 15.03.25 ECN15-545 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-604-041P		Purchased	No			110	Each	0.0000	1	1			
D350-604-041P									**				
Rear Locker Extender													
D2268		Manufactured	No			140	Each	13.0000	1				
D2268									**				
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		13							
				130951		1							
				132546		12							
D2728-1		Manufactured	Yes			140	Each	0.0000	1	1			
D2728-1									**				
Dart Logo Label Small													
D2269		Manufactured	No			155	Each	20.0000	1				
D2269									**				
Placard													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST006		8							
				131139		8							
				ST012a		12							
				135175		12							

DAS
27
9-89

DAS
27
9-89

AUG 29 2016

DAS
28
9-89

1X Sp/6-05-26.

1X B141 998 pc

1X B143 907 pc

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐				
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
☐ OTHER : _____						

Picklist Print

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Work Order ID: 142026

142026

Parent Item: D350-604-041

D350-604-041

Parent Item Name: Rear Locker Extender

Start Date: 2/23/2016

Required Date: 6/10/2016

Start Qty: 1.00

Required Qty: 1.00

D5062-041

Manufactured No

155 Each

19.0000 1

D5062-041

Bracket Assembly

**

① 03143454 JX

DAS
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7-89

DAS
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9-83

Location

Loc Qty

Loc Code

ST147

19

130525

14

131060

5

AUG 29 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Misidentified ☐	Past Due ☐																																																																

TABLE 1

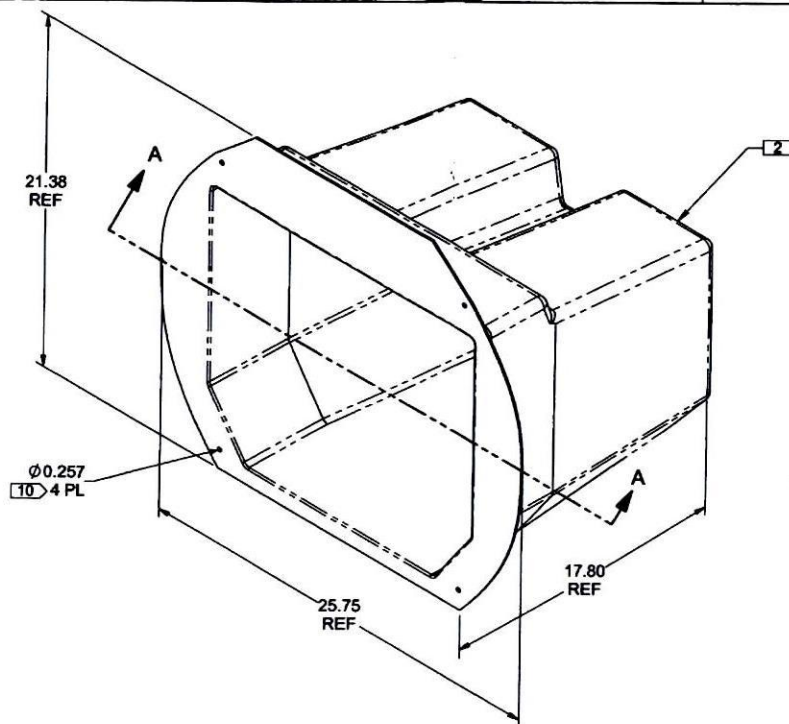
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

- 1) MATERIAL: SEE TABLE 3
- 2) FINISH: SEE TABLES 1, 2, & 3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5- 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO $\phi 0.257$
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



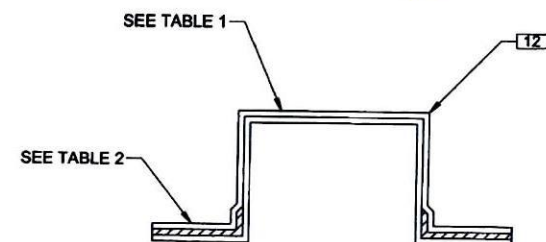
D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	POLYCOR 2330PAWK745 (WHITE)
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

142026 HCS
16-02-24



SECTION A-A

L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MAT'L PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-SLE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	CP		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D2273
REV. L
SHEET 1 OF 1
SCALE
350 REAR LOCKER EXTENDER NTS

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RELEASED
2015-11-03
EN 15-637

APPROVED

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
6	7725 FIBER GLASS
7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

1) MATERIAL: SEE TABLE 3

2) FINISH: SEE TABLES 1, 2, & 3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
ACCEPTABLE TO COVER CRACKS IN GELCOAT BY APPLYING A LAYER OF
PPG 6941241A 2C ACRYCOTE WHITE PAINT OVER GELCOAT

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 5.5- 7.5 lbs

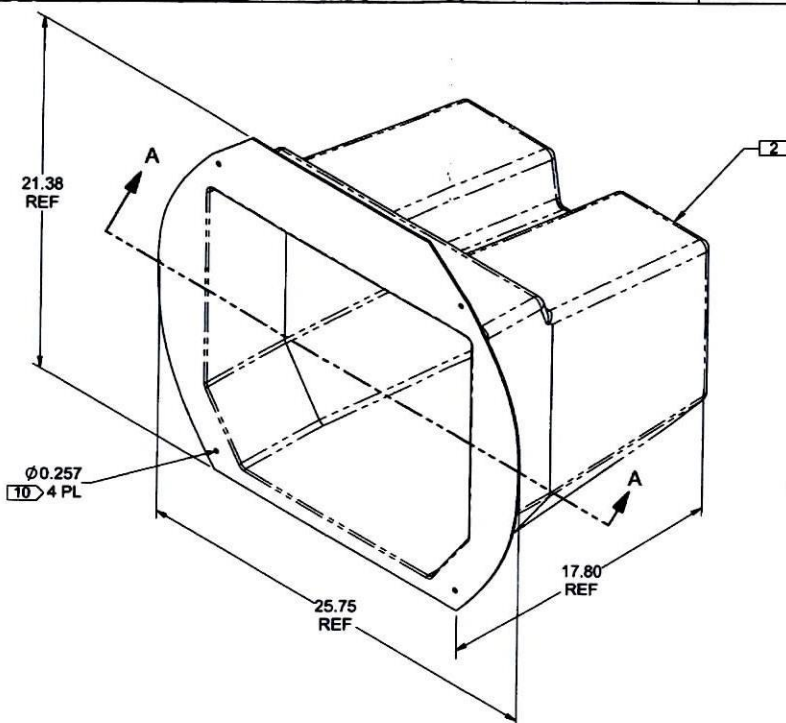
8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM

10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257

11) CONSTRUCTION: SEE TABLES 1 & 2

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

TABLE 3

MATERIAL USED	DESCRIPTION
GELCOAT	POLYCOR 2330PAWK745 (WHITE)
FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
FIBER GLASS CLOTH	HEXCEL 7725 FIBER GLASS
RESIN SYSTEM	DION 7704
PRIMER	TEMPO 4500-PB-23G (GREEN)

SEE TABLE 1

SEE TABLE 2

SECTION A-A

L	ADD PAINT OPTION (NCR 15-5408)	CP	15.10.19
K	LAYUP AND MATL PER FDC COMPOSITES PROCESS	CP	15.03.12
J	CHANGED GELCOAT TO 4314-001 DURA FR WHITE	ML	13.12.10
I	CHANGE GELCOAT TO POLYCOR 2330PAWK745	SFM	13.08.13
H	CHANGE MATERIAL & MANUFACTURING PROCESS	DC	13.03.15
G	ADD MANUFACTURING OPTION B, ZN B5-1	DC	12.08.08
F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	CP		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2273

REV. L

SHEET 1 OF 1

TITLE

350 REAR LOCKER EXTENDER NTS

SCALE

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2015-11-03
EN 15-637

APPROVED

TABLE 1

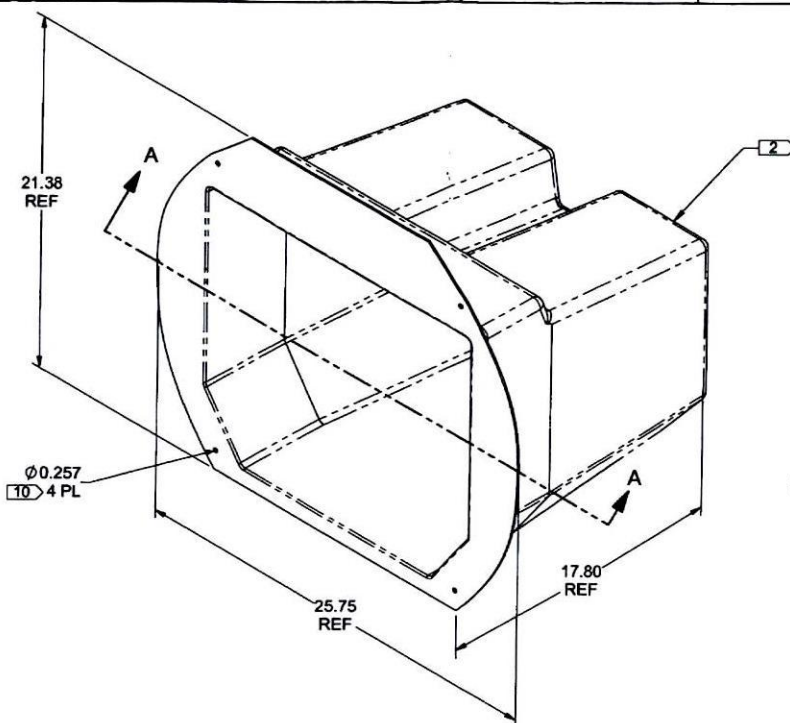
POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
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TABLE 2

POSITION	MATERIALS
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NOTES:

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- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 5.5- 7.5 lbs
- 8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
- 9) LAYUP USING DT9871 MOLD. WET LAYUP WITH BAG/VACUUM
- 10) TRIM & DRILL PER DT9905. OPEN HOLES TO Ø0.257
- 11) CONSTRUCTION: SEE TABLES 1 & 2
- 12) MATTE TO HOLD DOWN CORNERS AS REQUIRED



D2273 REAR LOCKER EXTENDER

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MATERIAL USED	DESCRIPTION
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FIBER GLASS MAT	OWENS CORNING 3/4 oz CHOPPED STRAND MAT
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SEE TABLE 1

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C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	96.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB		
DRAWN	CP		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADADRAWING NO.
D2273

REV. L

SHEET 1 OF 1

TITLE
350 REAR LOCKER EXTENDER NTSCOPYRIGHT © 1996 BY DART AEROSPACE LTD
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2015-11-03
EN 15-657

TABLE 1

POSITION	MATERIALS
1	TOOL SURFACE
2	GELCOAT
3	3/4 oz CHOPPED STRAND MAT
4	7725 FIBER GLASS
5	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

TABLE 2

POSITION	MATERIALS
1	TOOL SURFACE
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7	7725 FIBER GLASS
8	7725 FIBER GLASS
9	7725 FIBER GLASS
10	PRIMER

NOTES:

1) MATERIAL: SEE TABLE 3

2) FINISH: SEE TABLES 1, 2, & 3

ACCEPTABLE TO COVER CRACKS IN GELCOAT BY APPLYING A LAYER OF
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7) WEIGHT: 5.5- 7.5 lbs

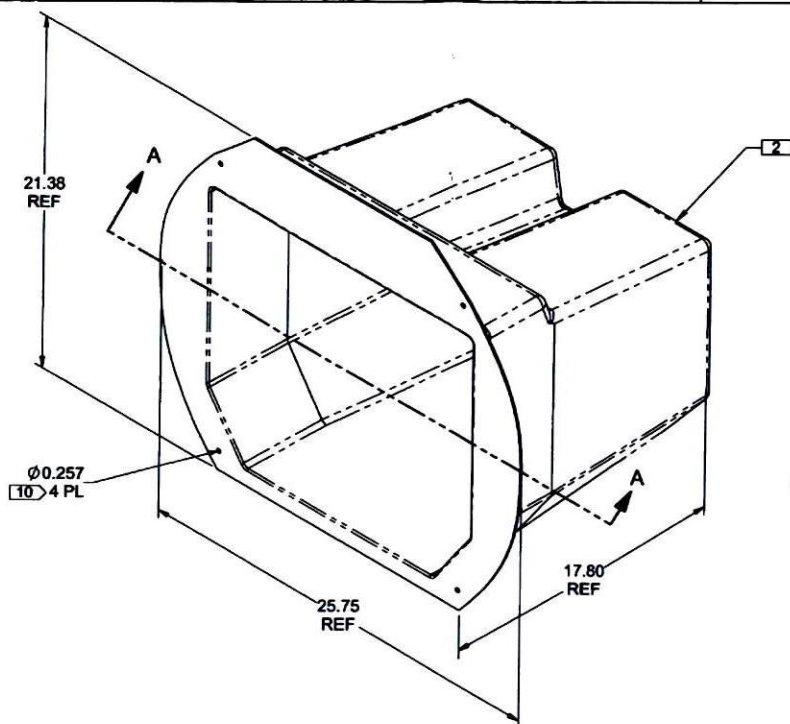
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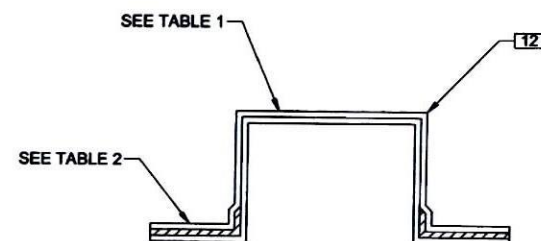
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D2273 REAR LOCKER EXTENDER

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MATERIAL USED	DESCRIPTION
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DRAWN	CP		
CHECKED	AP		
MFG. APPR.	JLM		
APPROVED	WM		
DE APPR.	DS		
DATE	15.10.19		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D2273

REV. L

SHEET 1 OF 1

TITLE

350 REAR LOCKER EXTENDER NTS

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2015-11-03
EN 15-637

APPROVED



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO31489

Purchase Order Date 2/25/2016
PO Print Date 2/25/2016

Page Number 6 of

Order From : VC-FDC01

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST-JEAN-SUR-RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 450-357-1344 ext303

Ship To Contact
Ship To Phone
Ship Via: Journey Freight collect
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

Line Total: \$835.00

16 D350-604-041P ✓

Rear Locker Extender

5/12/2016
Yes
5/12/2016

1.00
Each ✓

\$835.00 \$835.00

AS PER DWG.D2273 REV.L
B142025 ✓

Line Total: \$835.00

17 D350-604-041P

Rear Locker Extender

6/16/2016
Yes
6/16/2016

1.00
Each

\$835.00 \$835.00

AS PER DWG.D2273 REV.L
B142026

SP/6-05-26

Line Total: \$835.00

18 D350-604-041P

Rear Locker Extender

6/16/2016
Yes
6/16/2016

1.00
Each

\$835.00 \$835.00

AS PER DWG.D2273 REV.L
B142027

Note:

2/25/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5 **Tél.:** 450 357-1344

Bon de livraison 19/05/2016

Commande : 2408 Rev. A
Référence : PO #31489/9-20

Client : Dart

DART AEROSPACE
1270 Aberdeen Street
Hawksbury, ON
K6A 1K7

Expédier à

Même

Tél.: 1 613 632-9577

No item	Description	Qté	Qté livrée	Qté B/O
	2016-03-24-3 As per DWG.D2273 Rev .L B142023			
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/15 2016-03-29-1 As per DWG.D2273 Rev .L B142024	1		
D350-604-041P ✓	REAR LOCKER EXTENDER PO item: 31489/16 2016-03-29-2 As per DWG.D2273 Rev .L B142025 ✓	1 ✓		
D350-604-041P ✓	REAR LOCKER EXTENDER PO item: 31489/17 2016-03-30-1 As per DWG.D2273 Rev .L B142026	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/18 2016-03-30-2 As per DWG.D2273 Rev .L B142027	1		
D350-604-041P	REAR LOCKER EXTENDER PO item: 31489/19 2016-03-31-1 As per DWG.D2273 Rev .L	1		

Sp/605-26

*** Suite autre page ***



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CERTIFICATE of CONFORMITY

Customer Name: Dart Aerospace.

Customer P/O Number: 31489

Rev. NC

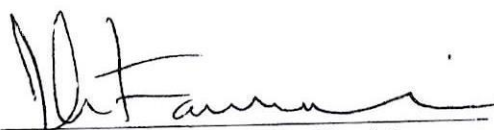
<u>PO Item</u>	<u>Qty</u>	<u>Part number</u>	<u>Dwg number</u>	<u>Description</u>	<u>Dart ID</u>	<u>FDC ID</u>	<u>Lot</u>
9	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142018	DAE001-074	2016-03-11
10	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142019	DAE001-075	2016-03-23-1
11	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142020	DAE001-076	2016-03-23-2
12	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142021	DAE001-077	2016-03-24-1
13	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142022	DAE001-078	2016-03-24-2
14	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142023	DAE001-079	2016-03-24-3
15	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142024	DAE001-080	2016-03-29-1
16	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142025	DAE001-081	2016-03-29-2
17	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142026	DAE001-082	2016-03-30-1
18	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142027	DAE001-083	2016-03-30-2
19	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142028	DAE001-084	2016-03-31-1
20	1	D350-604-041P	D2273 Rev L	350 Rear Locker Extender	B142029	DAE001-085	2016-03-31-2

NOTE : Paint process : interior surface re-painting as specified on Darts's PO by sanding gelcoat to remove cracks and application of PPG 6941241A 2C Acrycote White paint Lot 01516. Catalyst was PPG 794002 2C Acrycote Lot 98841.

Catalysed PPG acrycote paint complies with FAR 25.853 Appendix F Part I (b)-Par.4 (Vertical Test 60 seconds).

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature:


Jules Fournier, BDI, Quality Manager

Date: 2016-03-31